

Work Order ID 123163

July-29-14 2:32:29 PM

\*123163\*

Page 1

Item ID: D5106-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 7/29/14

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 8/08/14

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D5106

A

100

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.63" long

12

Ø

MH

14/08/02

110

0.00

\*110\*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-MILL as per folio FB332&dwg.

FOLIO REV: A

DWG REV: A

2-Deburr as required

12

3

MH

14/08/02  
14/08/03

P to Last Page

Work Order ID 123163

July-29-14 2:32:30 PM

\*123163\*

Page 2

Item ID: D5106-1

Accept

\*N900040100\*

Setup Start \*NS1\*

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Stop \*NS2\*

Item Name: Bracket

Start Date: 7/29/14

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\*12\*

Cust Item ID:

Required Date: 8/08/14

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\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Quality Control

Memo

manual will  
per - inspect

0.00

Drill .129" thru at 45°

12

3

12

0

12

0

S.C.L.

S.C.L.

14/08/05

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Quality Control

Memo

0.00

14.08.06 12 φ

140

Identify as per dwg &amp; Stock Location:

0.00

\*140\*

Packaging

Memo

ST/35

0.00

Packaging

14/8/8

DAS  
32  
9-89

(12)

**Work Order ID 123163****\*123163\***

Page 3

July-29-14 2:32:30 PM

Item ID: D5106-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 7/29/14

Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 8/08/14

Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

MLJ 14-08-11

④ 4.8.8

# Picklist Print

July-29-14 2:32:29 PM

Page 1

Work Order ID: 123163

**\*123163\***

Parent Item: D5106-1

**\*D5106-1\***

Parent Item Name: Bracket

Start Date: 7/29/14

Required Date: 8/08/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV A RQ VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased		No		100	f	11.2716	0.219	3			

**\*M303B2 000X1 750\***

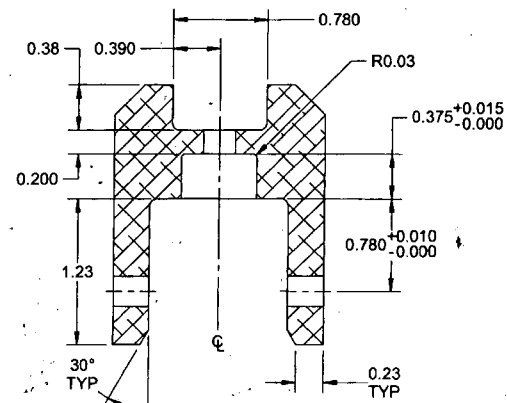
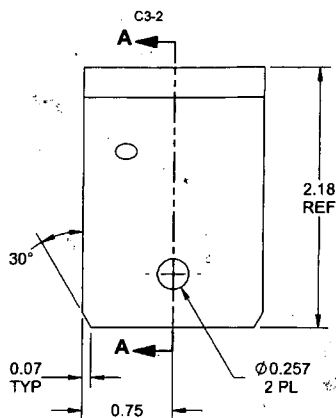
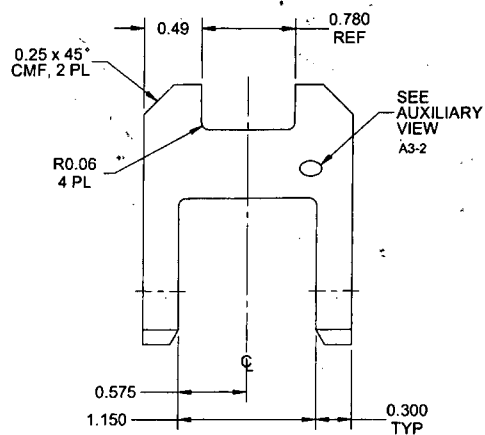
**\*\***

303 BAR 2" X 1.750"

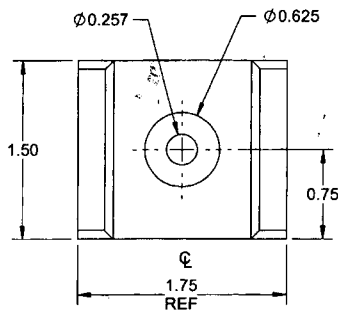
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT049	11.271579	
m126737	0.79	
m127888	1.664879	
m129286	8.8167	

1.664879  
0.92

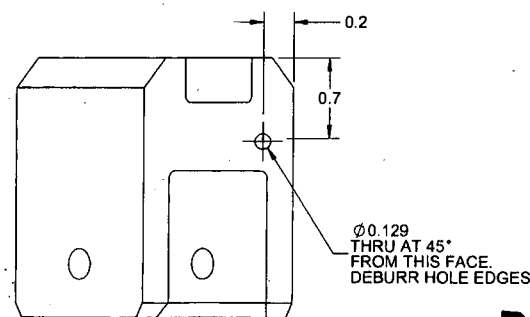
MM  
14/08/02



**SECTION A-A** D5-2



**D5106-1 BRACKET**



**AUXILIARY VIEW** D6-2

**NOTES:**

- 1) MATERIAL: AISI 303/304/316 SS BAR  
PER ASTM A582 OR ASTM A240 OR ASTM A276  
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs

*WLO 123263*

**RELEASED**  
2014-07-24

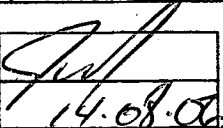
APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5106	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>BRACKET ASSEMBLY</b>	NTS
DATE	14.04.11	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 123163
<b>Description:</b>	<b>Part Number:</b> D5106-1
<b>Inspection Dwg:</b> D5106 <b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.780	+ .01 - .000	.783	✓		MH-04	Caliper.
.49	± .03	.490	✓			
.25 x 45°	+ .03 x .5°	.25 x 45°	✓			
.780	± .010	.777	✓			
.575	± .010	.570	✓			
1.150	± .010	1.150	✓			
.300	± .010	.291	✓			
2.18	± .03	2.178	✓			
Ø .257	+ .006 - .001	.257	✓			
.75	± .03	.745	✓			
.07 x 30°	± .03 x .5°	.100	✓			
.38	± .030	.378	✓			
.200	± .010	.191	✓			
.375	+ .015 - .000	.382	✓			
1.23	± .03	1.23	✓			
<del>.780</del>	<del>± .01</del>	<del>.783</del>	<del>✓</del>			
.23	± .03	.240	✓			
1.50	± .03	1.50	✓			
1.75	± .03	1.749	✓			
.75	± .03	.75	✓			
Ø .257	+ .006 - .001	.257	✓			
Ø .625	± .010	.624	✓			

<b>Measured by:</b> NH	<b>Audited by:</b> 	<b>Preliminary Approval:</b>
<b>Date:</b> 14/08/03	<b>Date:</b> 14.08.06	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	=

10.04.15

DQA:

Date:

14/08/14

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

14-8-13

Work Order update only ☐

Work Order: <u>123163</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>DS106-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4133</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Feeds and Speeds not set properly. Parts moved. (New prog)		Scrap and destroy	MH		
Doc/Data					DAS	replace w/ Batch	14/08/03		DAS
Equip/Tooling					16	#127888			16
Handling/Pre					9-89				9-89
Material									
Operator	14/08/03	110	3	Rel. Program not count	Q2042				Q2042
Offset/Setup					14/08/05	Fix Poson.			14/08/05
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input checked="" type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input checked="" type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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